



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

D135-1027-243
Job Sheet 170193

Accounting Job RD17-1027-01

Tel (613) 632-5200



Part No: D135-1027-243

Job Qty: 1 ea

Part Name: MID HEIGHT AFT Crosstube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: R+D

Description:

Note: D135-1027-243 REV.B IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP IPP REV:B 17.10.24 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Container		
100	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish1		
110	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-1		AB APR 26 2018
120	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish4		AB APR 26 2018
130	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		38
140	SprayPaint	1 pcs	1/19/18	1/19/18	0.00	1.00	Spray Paint		AB APR 27 2018
150	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC14		38
170	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-1	LG050	AB MAY 02 2018
180	QC21-SA	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		AB MAY 07 2018

Part Op 100 - ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4
Descriptions: 120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE
NUT AND CROSSTUBE USING SEALANT (NOTE 10) *beefy 138857 Proseal 138784 exp 9/18*
140 - ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE 11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE
PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: *138408* 2- PAINT OUTSIDE SURFACE AS
PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: *138819* 3- COAT INSIDE SURFACE WITH LPS
N/A *1/18/18*
PROXYON AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE
WITHIN 0.1" OF CENTERLINE QSI 044 6.1 (SEE NOTE 12 AND 13)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D135-1027-253 <i>5062543</i> ①	1	0	0	0
	D5511-1 <i>166507</i> ③	7	7	0	0
	MS35650-304 <i>FM137878</i> ⑤	60	60	0	0
	NAS1149D0363J <i>5015269</i> ⑥	4,315	4,315	0	0

Part Specifications



Container No: S066281



Part: D135-1027-243

Job No: 170193

Serial No/Batch: S066281

Revision: B

Inspector:

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Plex 1/11/18 10:30 AM dart.poulin.mario

P.T.O.

ml 19 Jun 2019



DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 170193 Date: JUN 19 2019

Work Order update only ☐

Work Order: <u>170193</u>		DISPOSITION				AGAINST DEPARTMENT/PROCESS													
Part No. <u>D135-1027-243</u>		Rework ☒ Scrap ☐ Use-as-is ☐				Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐				Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐									
NCR No. <u>19-7181</u>		Suspected Unapproved				Skid-tube Machining ☐ Thermoforming ☐ Large Fab ☐				Engineering Quality ☒ Other ☐									
Date: <u>16/5/2</u>		Step #: <u>140</u>		QTY Effective: <u>2</u>		MRB <u>130517</u> Approval <u>12 9-89</u> 16/5/2													
Description Work Order Deviation										Disposition									
Dwg cells for Procyon on inside surface of crussure.										Not required. Difficult to apply and process not done on other crussure. Dwg will be revised to remove procyon before STE approval <u>18 MAY 02 2018</u>									
Root Cause										FAULT CATEGORY									
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐									
Design ☒		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐									
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐									
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐									
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐									
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐									
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐									
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐									
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☒		Misread ☐									
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐									
Past Expiry Date ☐		Manufacturing Process ☐		OTHER: ☐															
Misidentified ☐		Past Due ☐																	